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D3407-1**Job Sheet 188218****Part No:** D3407-1**Job Qty:** 25 pcs**Part Name:** Stem**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 1/4/19**Job Tracking No:****Due Date:** 1/31/19**Created By:** Jesse White**Type:** SOLD**Description:**

Note: IPP Rev:A 05.10.18 New issue KJ/EC IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC IPP REV:D 17.11.02 AS PER DWG REV.G DD
VERF:JFS

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	25 pcs	1/31/19	1/31/19	0.00	10.04	Doosan - 1		
110	QC 2	25 pcs	1/31/19	1/31/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

120	QC 8	25 pcs	1/31/19	0.00	0.00	QC 2 - 8	
						QC 8 - 12	
						QC 8 - 14	2/19/10/107
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 38	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
130	Packaging 3-1 - Stock - B4B	25 pcs	1/31/19	0.00	0.00	Packaging 3 - 1 - B4B	WA001-4 JAC
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
140	QC 21 - SA	25 pcs	1/31/19	0.00	0.00	QC 21 - SA - 21	DAS 21 JAN 08 2019 9-00
						QC 21 - SA - 70	

Part Op 100 - 1-Turn as per Folio FA596 Rev: ____ & Dwg D3407 Rev: ____ Mill slot width at max tolerance .260" 2-Deburr

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Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - (Identify as per dwg & Stock Location: _____) LOCATION: WA001
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-R0.750	17-4 Round Bar .750	11.4750 ft (.459 ea)	100-Doosan - 1	S123416

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M17-4-R0.750	11	31	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.063Inches ± 0.010	0.073 0.053		
2	Tow Ring	0.26520inches + 0.00160 - 0.00170	0.26680 0.26350	1/4-28 UNF	Go/No Go
3	Tow Ring	0.24575inches ± 0.00325	0.24900 0.24250	Major	
4	Tow Ring	0.625Inches ± 0.010	0.635 0.615		
5	Tow Ring	0.363Inches ± 0.010	0.373 0.353		
6	Tow Ring	0.750Inches ± 0.010	0.760 0.740		
7	Tow Ring	0.100Inches ± 0.010	0.110 0.090	Radius	
8	Tow Ring	0.470Inches ± 0.010	0.480 0.460		
9	Tow Ring	0.500Inches ± 0.010	0.510 0.490		
10	Tow Ring	3.25inches ± 0.01	3.26 3.24		
11	Tow Ring	4.250Inches + 0.000 - 0.010	4.250 4.240		
12	Tow Ring	5.270Inches ± 0.010	5.280 5.260		
13	Tow Ring	0.150Inches ± 0.010	0.160 0.140		
14	Tow Ring	0.550Inches ± 0.010	0.560 0.540		
15	Tow Ring	0.625Inches ± 0.010	0.635 0.615		
16	Tow Ring	0.250Inches + 0.010 - 0.000	0.260 0.250		

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11.02 Feet

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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
FAULT CATEGORY Power Loss/Supply Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence 01" x 1" Set-up 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 01/07/19			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ PI ☐ Bi ☐ Ci ☐ Ci ☐ Ci ☐ M ☐ M ☐ Other ☐			DART AEROSPACE Container No: S142553 Part: D3407 - 1 Job No: 188218 Serial No/Batch: S142553 Revision: G Inspector: Exp Date: Instructions: Various STC's Date: 01/07/19		